

Date: Monday, 27/04/2009 11:30:46 AM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STRUT		
Job Number	47548			Part Number	D2565109		
Estimate Number	10284			Drawing Number	D2565 REV E		
P.O. Number				Project Number	N/A		
This Issue	27/04/2009	S.O. No.		Drawing Revision	E		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	04/05/2009	Qty:	15
Previous Run	42102			Um:	Each		
Written By							
Checked & Approved By	<u>JD 09/04/27</u>						
Comment	Est:F 02.04.16 Added dwg Rev.C1 NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	<i>TM 102 245 ①</i> <i>TM 102 271 ①</i> <i>TM 108 846 ②</i> <i>M11096 ⑩</i> <i>S6 09/04/28</i> <i>(15)</i>
		Comment: Qty.: 1.0771 f(s)/Unit Total : 16.1564 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	
2.0	BRAKE NC	NC BRAKE	<i>S6 09/04/28</i> <i>(15)</i>
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	<i>(15x)</i> <i>09/04/28</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP	<i>S09/04/28</i> <i>(10)</i>
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	POWDER COATING	POWDER COATING	<i>m109996</i> <i>(15)</i> <i>09/04/30</i>
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	
	START TIME: OVEN TEMPERATURE: FINISH TIME:	<i>7:45</i> <i>400°</i> <i>8:15</i>	<i>CMD/FX</i> <i>(15)</i> <i>09/04/30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 11:30:47 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 47548

Part Number: D2565109

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



48



09-04-30

(15)

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

ST270

Pg/9/01 (15)



FINAL INSPECTION/W/O RELEASE



09/05/04 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

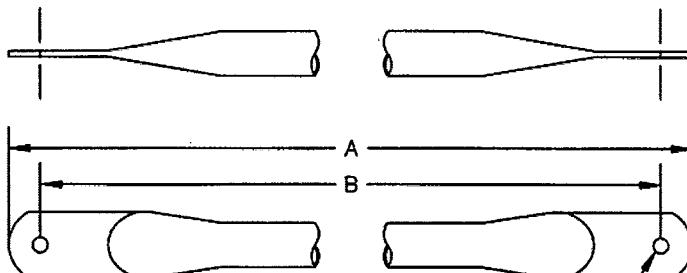
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3

RELEASED
 04.05.05


DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY
 PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL (REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4³ NO. 41548
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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